

Work Order ID 64354

Monday, December 06, 2010 3:23:45 PM



Page 1

Item ID: D4110-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, LH

Start Date: 12/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: RR

Date: 12/2/10

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4110

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.063

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

1310-12-17

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1310-12-17

Work Order ID 64354

Monday, December 06, 2010 3:23:45 PM

Page 2

Item ID: D4110-1

Accept

Setup Start

Revision 'D':

Stop

Item Name: Door Doubler, LH

Start Date: 12/2/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/12/17

(46)

130

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

8/10/12/21 (6)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12/21

(46)

-1/3

Work Order ID 64354

Page 3

Monday, December 06, 2010 3:23:45 PM

Item ID: D4110-1

Accept



Setup Start



Revisor 'D':

Stop



Item Name: Door Doubler, LH

Start Date: 12/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: 130

0.00

Memo

0.00

Packaging

12/14/21 (6)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/21 *[Signature]**MF*
10-12-21

Picklist Print

Monday, December 06, 2010 3:24:18 PM

Page 1

Work Order ID: 64354

Parent Item: D4110-1

Parent Item Name: Door Doubler, LH



Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

124.0000

0.0318

0.200842



304/316 Sheet .063



1810-12-17

Location

Loc Qty

Loc Code

MAT

124

111323

0

115953

124

115953

6

DART AEROSPACE LTD	Work Order: 64354
Description: Dash Double LH.	Part Number: D4110-1
Inspection Dwg: D4110-1, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

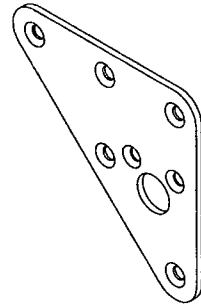
Measured by:	13
Date:	10-12-17

Audited by:	8
Date:	10/12/17

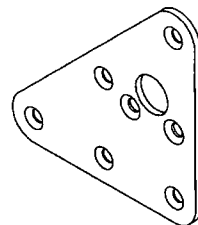
Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

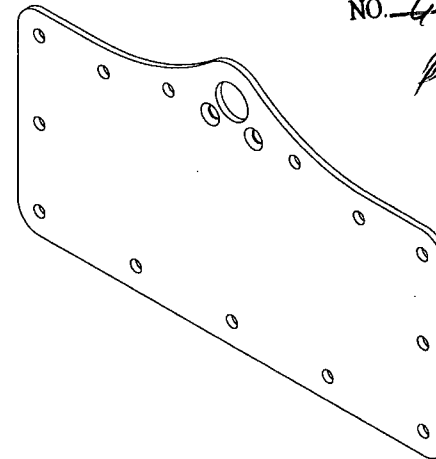
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 44354
P/1012-6



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR



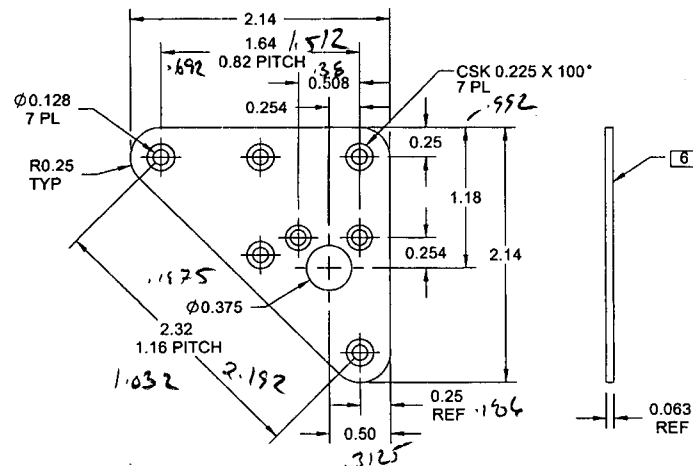
D4110-3 DOUBLER, SILL

RELEASED
 2010-09-23
md

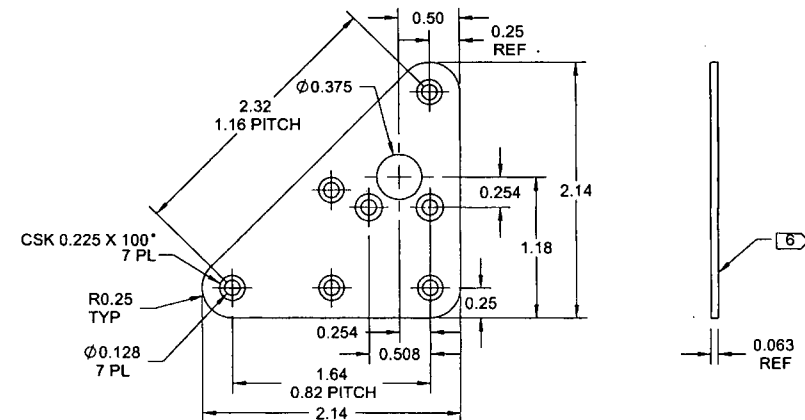
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4110 TITLE DOUBLER SCALE NTS	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.07.20	REV. A SHEET 1 OF 3	

COPYRIGHT © 2010 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD

u/o 44359



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR

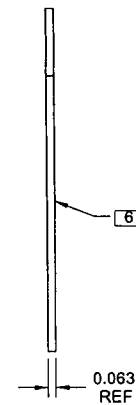
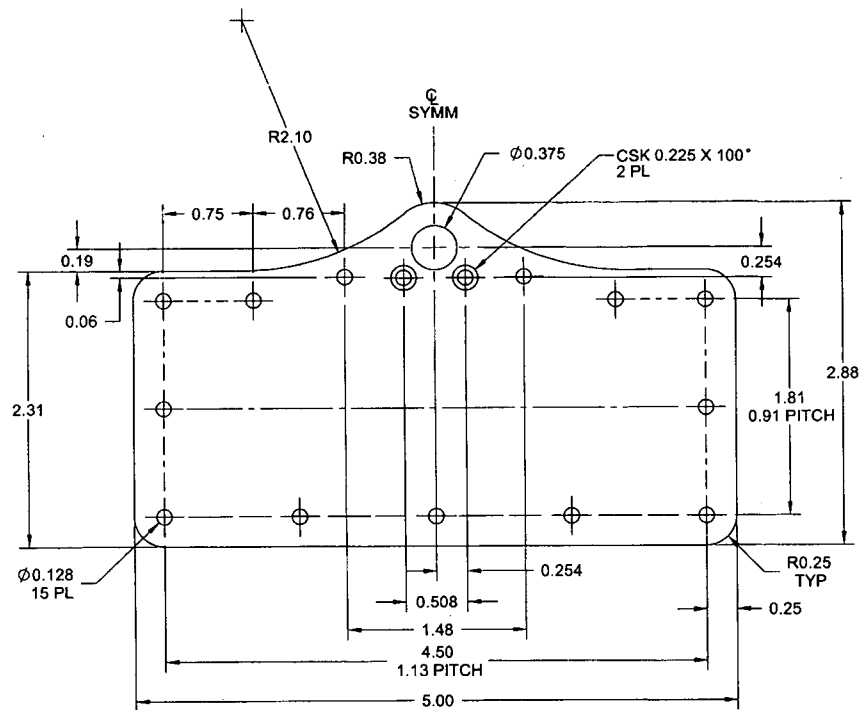
NOTES:

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

RELEASED
2010-09-23

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4110	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLER	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

w/o 64359



D4110-3 DOUBLER, SILL

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4110	REV. A
MFG. APPR.	JPH	TITLE DOUBLER	SHEET 3 OF 3
DE APPR.	JPH	SCALE NTS	
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	